

ABSTRACT

A spring coil assembly having a first row of coils arranged in a first
spacing pattern and a second row of coils adjacent the first row and arranged in a
5 second spacing pattern that is different from the first spacing pattern. The spring
coil assembly can be assembled using an apparatus comprising a main conveyor
adapted to convey a plurality of coils along an axis, an assembler which is
operable to intertwine a plurality of coils into a spring coil assembly, and a
transfer station operable to move a plurality of coils from the main conveyor into
10 the assembler. The transfer station includes a plurality of pusher arms each of
which include a gripper which is operable to grasp an individual coil, a carriage
supporting the gripper arms and means for shifting the carriage axially relative to
the axis so that a plurality of coils carried by the gripper arms are displaced in the
direction of travel of the conveyor.

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